

Work Order ID 109700

109700

Page 1

November-26-13 7:30:33 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/10/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-11-26 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2750-041	G
-----------	---

gp

0.00

100

1000

DOCUMENT CONTROL

DC

Document Control

Memo

record fwd angle: 89.7°

0.00

DAS
6
9-89

13/12/19

B *13/11/28*
m42

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

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Start Date: 11/26/13 Start Qty: 1.00 ***1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

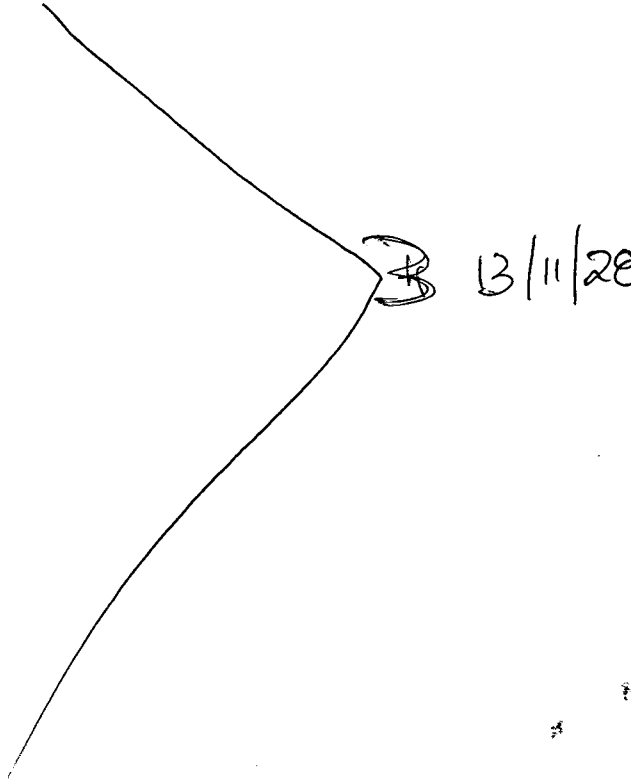
1- Pick D2600-3 Bent

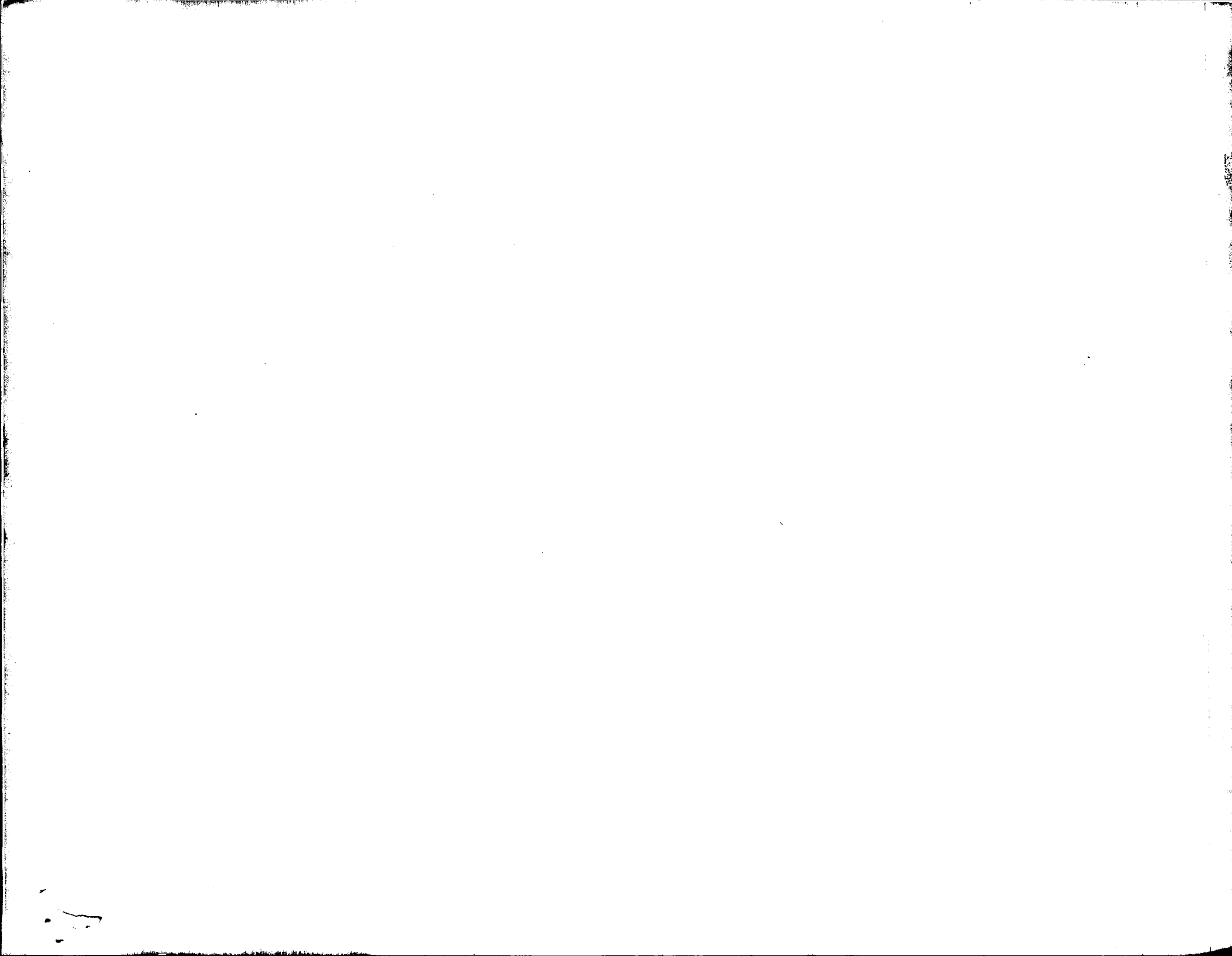
2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail C to 0.500" (8 holes per side)9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)


12/11/20



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Start Date: 11/26/13 Start Qty: 1.00 ***1***

Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: m126325 > BE13-11-29

12-Grind welds flush as per Dwg D2750

120

120

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

DAS
27

9-89

13/11/29

/

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

DAS
27

9-89

13/11/29

/

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November-26-13 7:30:33 AM

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N900040100

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Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 12/10/13 Req'd Qty: 1.00 *1*

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140	Chemical Conversion Coat per QSI005 4.1	0.00							
-----	---	------	--	--	--	--	--	--	--

140

Hand Finish

Memo

0.00

Hand Finishing

1 / 13-12-02 DG

150	QC7-Inspect Chemical Conversion Coat	0.00							
-----	--------------------------------------	------	--	--	--	--	--	--	--

150

QC

Memo

0.00

Quality Control

13-12-2

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109700

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Item ID: D350-636-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***Start Date: 11/26/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/10/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 127317
exp. date: 14/08/16

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: M126325

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

- DL 13/12/02

78E 13/12/03

13/12/04

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Item ID: D350-636-011

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Setup Start ***NS1***

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Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/10/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

> 13-12-05

170

QC10- Inspt visual per QSI004- ground welds 0.00

DAS

27

9-89

170

QC

Memo

0.00

13/12/15

Quality Control

180

QC5- Inspt part completeness to step on W/O 0.00

DAS

27

9-89

180

QC

Memo

0.00

13/12/15

Quality Control

VERIFY C'BOARD IS GOOD

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Item ID: D350-636-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.
 Start Date: 11/26/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/10/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
Hand Finish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.		-	mm		13/12/09			
200		0.00							
200									
Spray Paint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 126543					1	0	0	13-12-15
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 127534								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024					1			13-12-17

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Item ID: D350-636-011

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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/10/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

230

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1- Install inserts as per Dwg D2750

2-Inspect for Foreign Objects

3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11127317

EXP DATE: 141000

4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11121651

5- Coat all exposed fasteners with "LPS Procyon" batch: 1112900

DAS
27
9-89

13/12/17

240

QC5- Inspect part completeness to step on W/O 0.00

240

QC

Memo

0.00

Quality Control

11/11/13 11/12/17

1

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Item ID: D350-636-011**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube LH Aerazur / Apical Cylindrical Compat.**Stop *NS2*****Start Date:** 11/26/13 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 12/10/13 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** **Date:** **Tooling:** **Date:****Run Start *NR1*****QC:** **Date:** **SPC (Y/N):** **Date:****Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 13-12-23
MF
13-12-20

Picklist Print

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Page 1

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	341.0000	8	8			

D3492-1

Plug

**

13/12/13

Location	Loc Qty	Loc Code
FP001	341	
100504	2	
101063	3	
104844	283	
107914	24	
69531	8	
74444	2	
76235	4	
83098	7	
88541	3	
91466	2	
97266	3	

 X O

Picklist Print

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Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

267.0000

8

8

D3492-3

**

13/12/17

Plug

Location

Loc Qty

Loc Code

FP001

227

104853

102

106844

18

107331

89

81967

5

83099

3

85461

1

86865

2

95124

4

99012

3

FP002

40

107915

40

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Work Order ID: 109700

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

275.0000

8

8

NAS1611-010

O-RING

**

ll 13/12/17

Location

Loc Qty

Loc Code

FP001

275

110915

14

117460

8

118077

1

118612

3

119438

7

121259

2

121584

2

121723

7

122151

8

123348

29

123352

4

124580

4

125484

14

m126988

172

x8

NAS1149D0863J

Purchased

No

250

Each

1,124.000

2

2

NAS1149D0863.I

Washer

**

DAS

33

9-89

12-12-18

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

4

118078

4

ST294

1120

125268

600

125484

220

125635

300

125484

DAS
6
9-89

Picklist Print

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Work Order ID: 109700

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

65.0000

1

1

D2744

**

BE 12/11/29

(Gap)

Location

Loc Qty

Loc Code

LG001

65

100398

28

62715

1

97543

36

Manufactured No

110

Each

28.0000

1

1

D2600-3-BENT

D2600-3-BENT

**

(1) 13/11/28

Extrusion Bent

Location

Loc Qty

Loc Code

LG002

28

105198

1

107404

10

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

83305

1

97615

1

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Work Order ID: 109700

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

329.0000

8

8

D2743

Grossbolt Spacer

**

BE 13/12/03

Location

Loc Qty

Loc Code

LG001

329

101033

2

106245

12

106876

11

107359

131

107907

63

67766

4

68251

3

73403

64

74445

1

79517

2

81965

23

83262

2

85459

4

88504

2

95148

2

95901

2

97584

1

D2739

Manufactured No

160

Each

4.0000

1

1

D2739

35011 Beam

**

DE 13/12/02

Location

Loc Qty

Loc Code

LG002

4

106933

1

97319

1

97618

2

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D3490-3

Manufactured No

160

Each

116.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 13/12/03

Location

Loc Qty

Loc Code

LG001

116

103883

18

105603

31

107913

63

92443

1

95223

3

D3490-1

Manufactured No

160

Each

122.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 13/12/03

Location

Loc Qty

Loc Code

LG001

122

100560

2

101117

2

103881

2

105602

11

107419

87

62450

2

74875

4

77042

3

81976

2

94805

2

95977

1

97621

2

99074

2

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

Each

1,205.000

38

AI S4-1032-225

**

lll

13/12/17

Rivnut

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST280

381

M125954

20

M127028

361

st555

794

M127092

794

x38

D3793-3

Manufactured

No

230

Each

21.0000

1

1

D3793-3

**

lll

13/12/17

Wearplate Aft

Location

Loc Qty

Loc Code

FP001

13

104212

12

92487

1

FP002

8

106663

8

x1

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

71.0000

1

1

AN8C35A

Bolt

**

ll 18/12/17

Location

Loc Qty

Loc Code

FG

5

121275

5

FP001

65

115960

1

121275

1

m126293

33

m127061

30

st507

1

124827

1

yl

D3793-1

Manufactured

No

230

Each

22.0000

1

1

D3793-1

Wearplate Fwd

**

ll 13/12/17

Location

Loc Qty

Loc Code

FP002

22

100333

1

105532

6

109205

9

82171

2

87273

3

92382

1

yl

D3488-041

Manufactured

No

230

Each

13.0000

1

1

D3488-041

Blade Fitting LH

**

ll 13/12/17

Location

Loc Qty

Loc Code

FP001

13

100823

1

103877

7

106696

5

yl

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Work Order ID: 109700

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Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

29.0000

1

1

D3794-3

Gasket Aft

**

11/26/13

Location

Loc Qty

Loc Code

FP001

29

105529

8

108413

18

74530

2

92658

1

x1

AN6C44A

Purchased

No

230

Each

130.0000

4

4

AN6C44A

Bolt

**

11/26/13

Location

Loc Qty

Loc Code

FG

2

103964

2

st503

128

m127300

128

x4

MS21083C8

Purchased

No

230

Each

92.0000

1

1

MS21083C8

Nut

**

11/26/13

Location

Loc Qty

Loc Code

ST319

89

123900

3

125484

1

m126274

10

m127255

75

x1

ST506

3

124308

3

Picklist Print

Page 10

November-26-13 7:30:38 AM

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

38.0000

1

1

D3536-25

Gasket Center

**

ml 13/12/13

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

32

105965

2

109206

26

83900

1

89057

1

93696

1

95686

1

x1

D3631-1

Manufactured No

230

Each

217.0000

8

8

D3631-1

Washer

**

ml 13/12/13

Location

Loc Qty

Loc Code

FP001

202

106188

4

106837

76

107324

100

81874

2

83588

18

91606

1

94702

1

y 2

FP002

15

68062

2

75548

13

November-26-13 7:30:38 AM

Shop Packet Print

Page 10

Picklist Print

Page 11

November-26-13 7:30:38 AM

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

15.0000

1

1

D3791-1

Wearpad

**

ll 12/12/17

Location

Loc Qty

Loc Code

FP002

15

106144

12

62239

2

83392

1

x1

NAS1149C0332R

Purchased

No

230

Each

12,091.00

38

38

NAS1149C0332R

WASHER

**

ll 12/12/17

Location

Loc Qty

Loc Code

FP001

254

123355

254

ST292

119

123248

18

123759

10

125268

91

st510

10016

m126319

4516

m127306

2500

m127410

3000

ST511

1576

125654

1576

ST517

126

124580

126

x39

November-26-13 7:30:38 AM

Shop Packet Print

Page 11

Picklist Print

November-26-13 7:30:38 AM

Page 12

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 318.0000 8 8

D2745

Bushing

**

ll 13/12/17

Location

Loc Qty

Loc Code

ST017

318

106847

120

107336

124

107908

74

x8

AN3C5A Purchased No 230 Each 516.0000 34 34

AN3C5A

Bolt

**

ll 13/12/17

Location

Loc Qty

Loc Code

FG

5

122800

5

ST350

511

m127290

511

x34

D3537-1 Manufactured No 230 Each 97.0000 3 3

D3537-1

Wearpad

**

ll 13/12/17

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

79

100524

6

107384

13

108118

60

x3

November-26-13 7:30:38 AM

Shop Packet Print

Page 12

Picklist Print

November-26-13 7:30:38 AM

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

252.0000

1

1

NAS1149C0832R

**

lll 13/12/13

Washer

Location

Loc Qty

Loc Code

ST292

252

122441

102

m125807

150

X1

AN3C6A

Purchased

No

230

Each

739.0000

4

4

AN3C6A

**

lll 13/12/13

Bolt

Location

Loc Qty

Loc Code

FG

10

122416

10

FP001

30

122599

30

FP002

1

111982

1

ST350

17

122416

17

ST512

681

m125709

681

X 4

Picklist Print

Page 14

November-26-13 7:30:39 AM

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

230.0000

8

8

NAS1611-013

O-RING

**

ll 13/12/17

Location

Loc Qty

Loc Code

FP001

230

116582

5

117291

2

117887

53

119623

36

121825

10

122993

3

124231

1

125445

120

x 8

D3535-25

Manufactured

No

230

Each

26.0000

1

1

D3535-25

Wearplate Center

**

ll 13/12/17

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

24

105549

9

106128

11

62233

1

81357

1

87385

1

90061

1

✓

November-26-13 7:30:39 AM

Shop Packet Print

Page 14

Picklist Print

November-26-13 7:30:39 AM

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

27.0000

1

1

D3794-1

Gasket Fwd

**

M 12/12/13

Location

Loc Qty

Loc Code

FP001

27

101046

1

104620

2

108497

8

109207

12

87631

2

92426

1

95913

1

x1

MS21043-6

Purchased

No

230

Each

338.0000

4

4

MS21043-6

NUT

**

M 12/12/13

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

252

117887

2

120308

2

124231

2

m127255

246

ST506

66

124485

66

x2

x2

Picklist Print

November-26-13 7:30:39 AM

Page 16

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

118.0000

2

2

D3493-1

Washer

**

DAS

33

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

108

105613

48

107916

60

105613

DAS
33
9-89

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

MS21083C8

Purchased

No

250

Each

92.0000

2

2

MS21083C8

Nut

**

DAS

33

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST319

89

123900

3

125484

1

m126274

10

m127255

75

ST506

3

124308

3

127255

DAS
33
9-89

AN8C21A

Purchased

No

250

Each

79.0000

2

2

AN8C21A

Bolt

**

DAS

33

9-89

13-12-18

DAS
6
9-89

Location

Loc Qty

Loc Code

ST

2

123966

2

ST342

2

123966

2

ST505

75

m127061

75

127061

DAS
33
9-89

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Shop Packet Print

Page 16

Picklist Print

Page 17

November-26-13 7:30:39 AM

Work Order ID: 109700

109700

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 11/26/13

Required Date: 12/10/13

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

205.0000

4

4

***NAS1515H3I ***

Washer

**

ll 13/12/13

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

165

121556

45

124542

120

✓✓

D2741

Manufactured

No

250

Each

55.0000

1

1

D2741

Blade

**

DAS
33
9-89

Location

Loc Qty

Loc Code

FG

11

100664

6

85480

1

98323

4

ST466

44

104976

3

107206

38

71856

1

85480

1

98323

1

107206

DAS
6
9-89

DAS
37
9-89

D3532-1

Manufactured

No

250

Each

42.0000

2

2

D3532-1

Spacer

**

DAS
33
9-89

13-12-18

Location

Loc Qty

Loc Code

ST054

42

100519

42

100519

DAS
6
9-89

DAS
37
9-89

November-26-13 7:30:39 AM

Shop Packet Print

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D2750-041	350 SKIDTUBE ASSEMBLY, LH
1	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
1		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
1			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
1	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
1	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
1	1			D2750-2	SKIDTUBE WELDMENT, RH
1		1		D2750-3	SKIDTUBE WELDMENT, LH
1			1	D2750-4	SKIDTUBE WELDMENT, RH
1	1	1	1	D3488-041	BLADE FITTING, LH
1	1	1	1	D3488-042	BLADE FITTING, RH
1	4	4	4	D3490-1	SPACER
1	4			D3490-3	SPACER
1		4	4	D3490-5	SPACER
1	8	8	8	D3492-041	PLUG ASSEMBLY
1	8			D3492-043	PLUG ASSEMBLY
1		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
1	3	3	3	D3537-1	WEARPAD
1	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

1 09700 MJS
13-11-26 RELEASED
2013-08-13

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS, INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 06-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

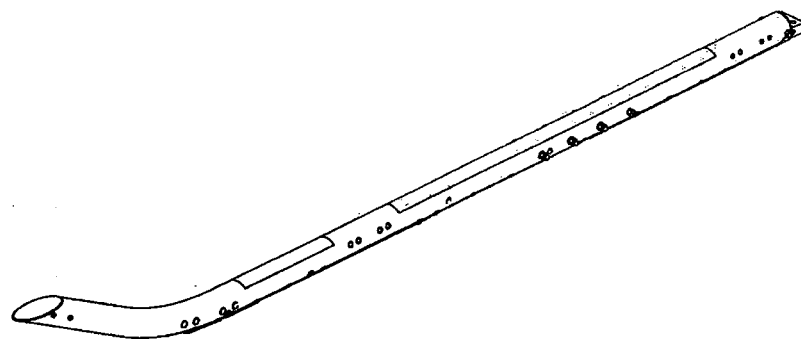
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750

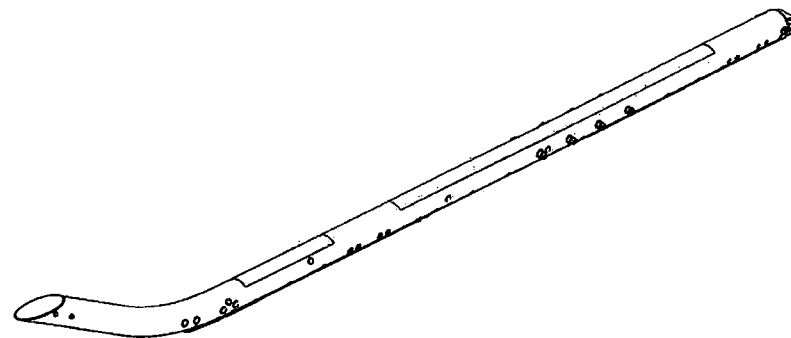
TITLE
350 SKIDTUBE ASSEMBLY

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REV. G
SHEET 1 OF 11
SCALE
NTS



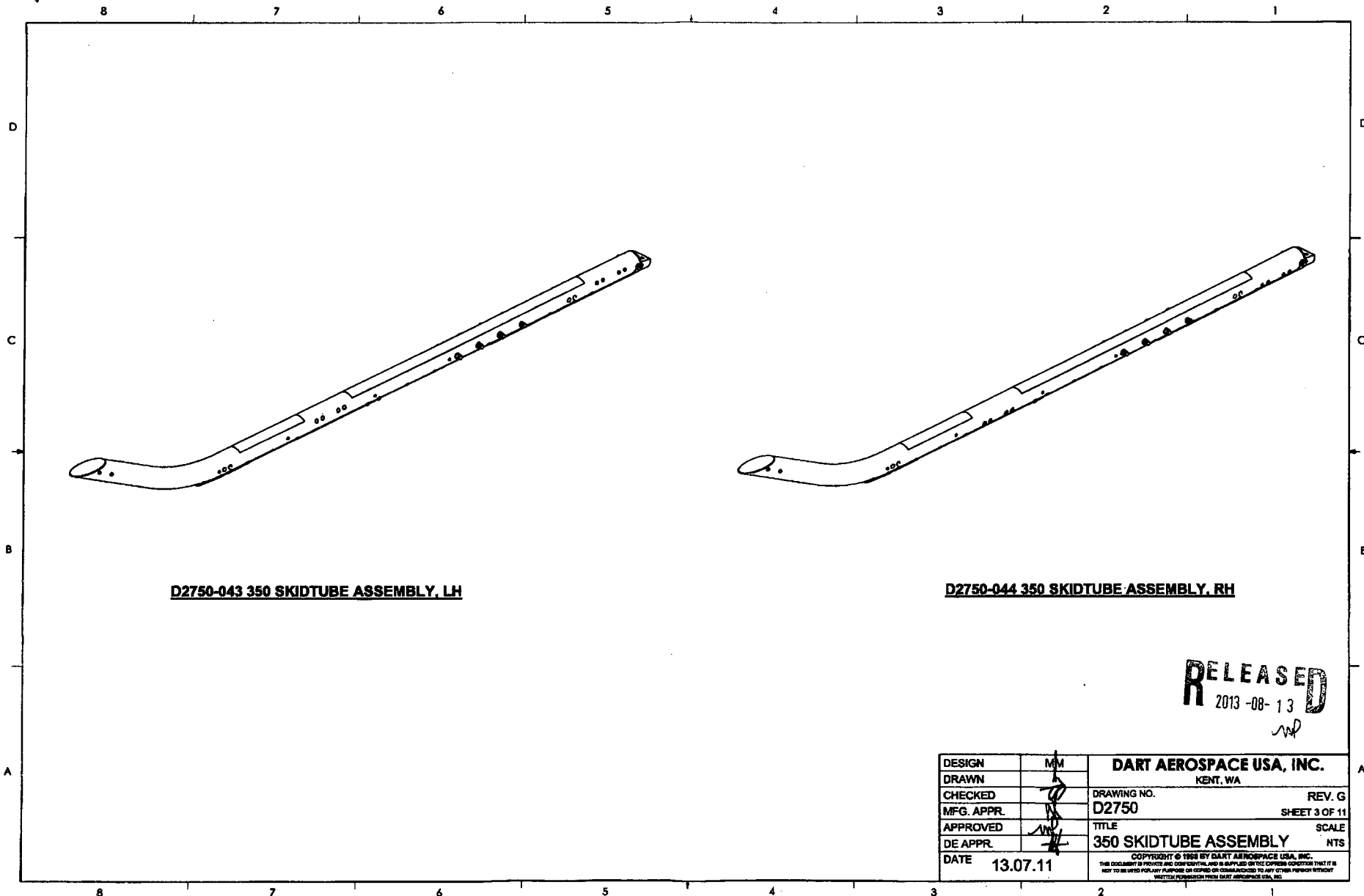
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MR

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROVIDED CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

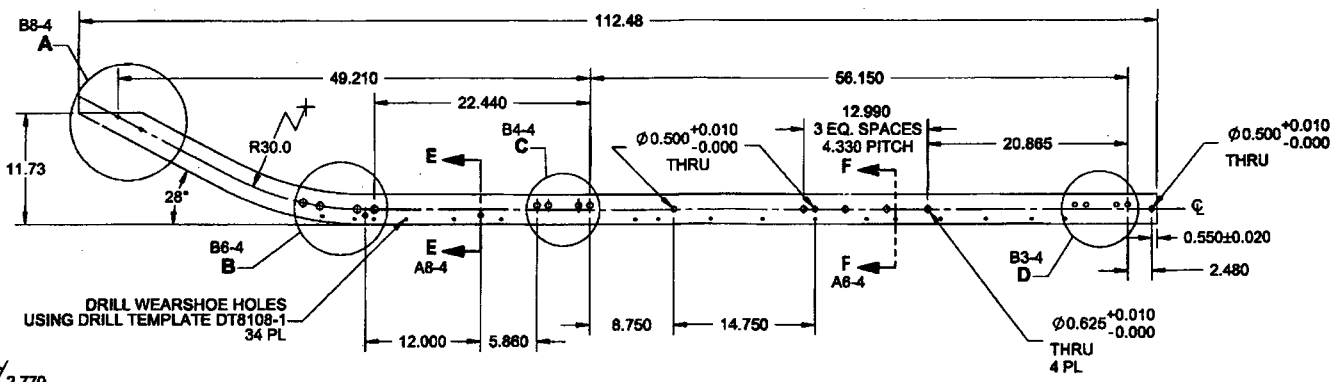


D2750-043 350 SKIDTUBE ASSEMBLY, LH

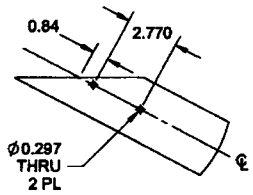
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
WDP

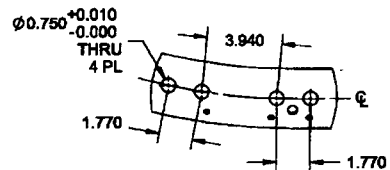
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



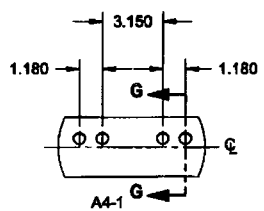
D2750-1 LH SKIDTUBE



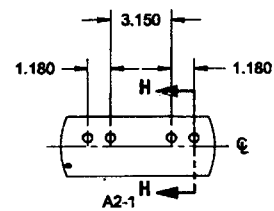
DETAIL A
SCALE 2X



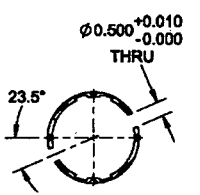
DETAIL B
SCALE 2X



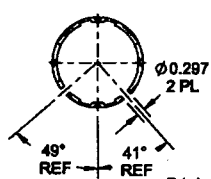
DETAIL C
SCALE 2X



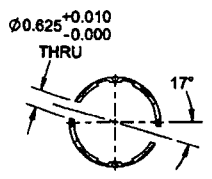
DETAIL D
SCALE 2X



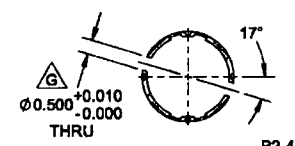
SECTION E-E
SCALE 3X, 2 PL



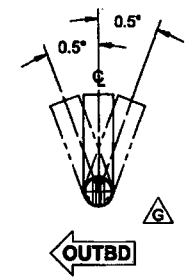
SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



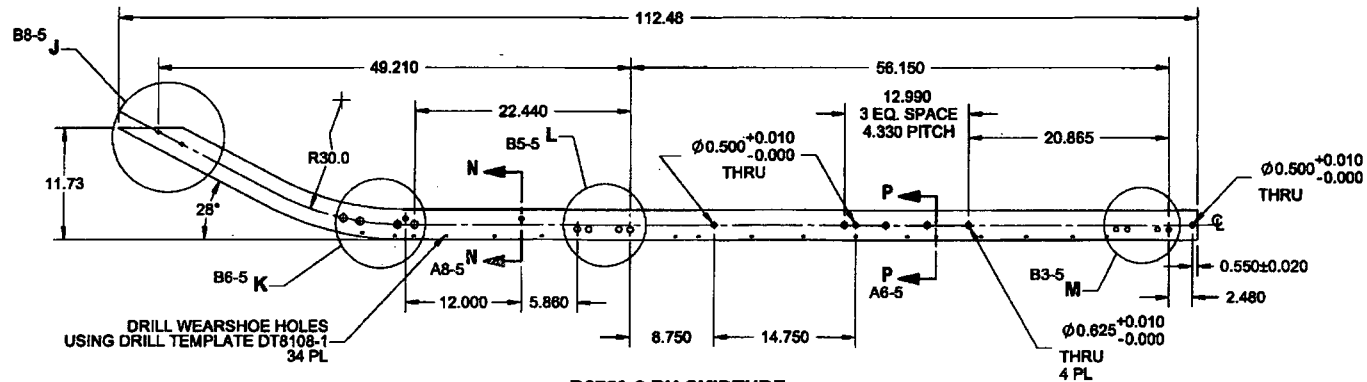
SECTION H-H
SCALE 3X, 4 PL



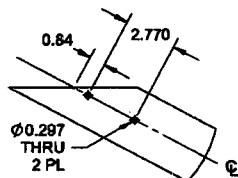
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

RELEASED
2013-08-13

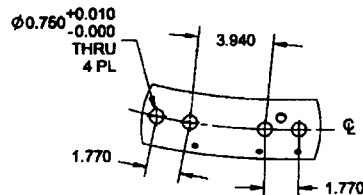
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small> COPYRIGHT © 1989 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	



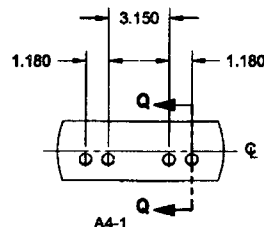
D2750-2 RH SKIDTUBE



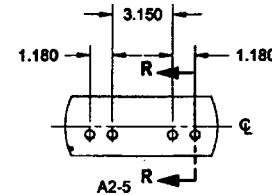
DETAIL J
SCALE 2X



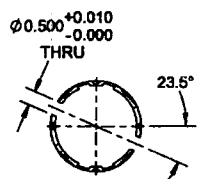
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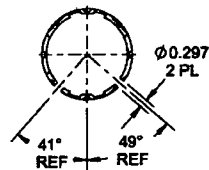
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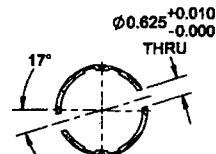
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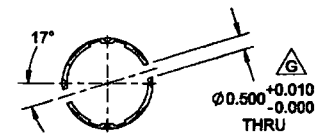
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



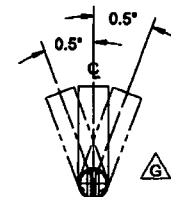
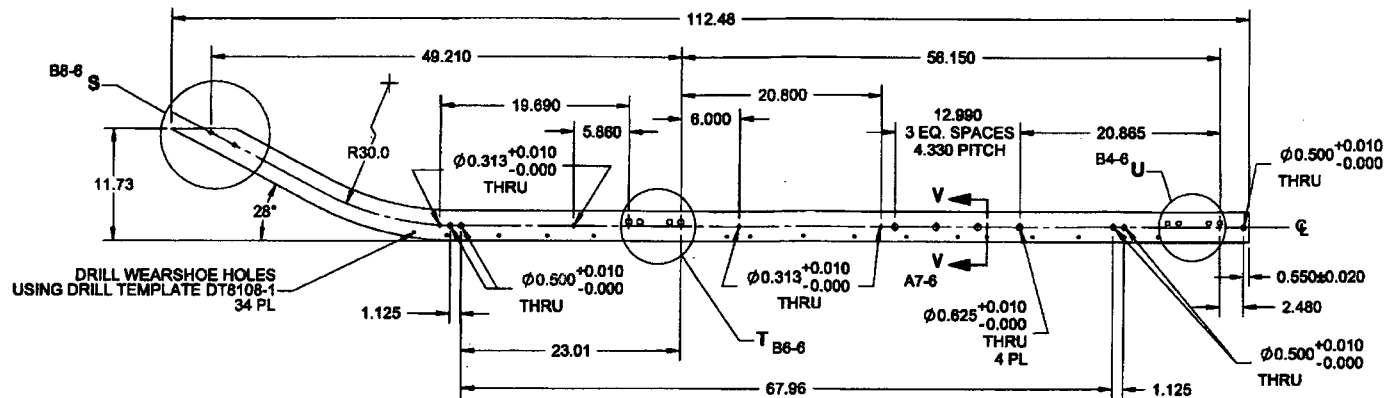
SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

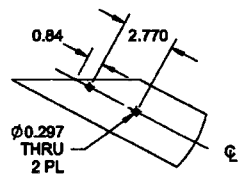
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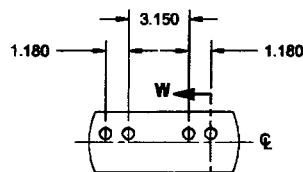


OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

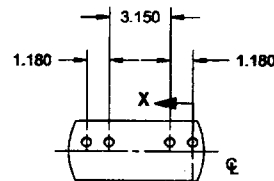
D2750-3 LH SKIDTUBE



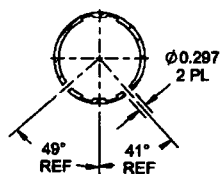
DETAILS S
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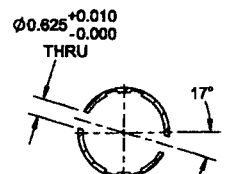
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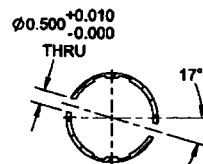
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL








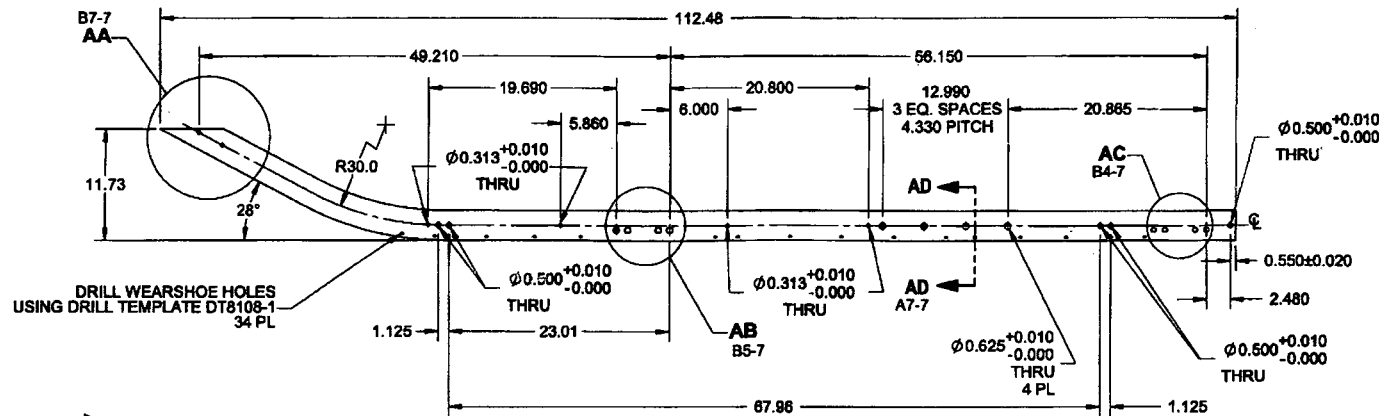
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SCALE 3X, 4 PL



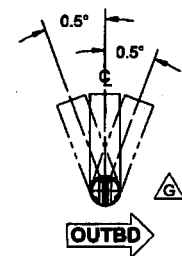
SECTION X-X
SCALE 3X, 4 PL

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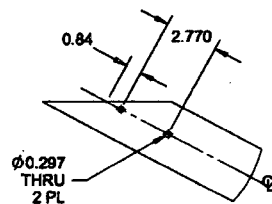
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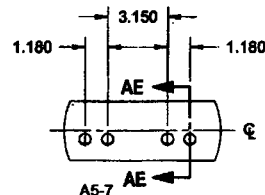
D2750-4 RH SKIDTUBE



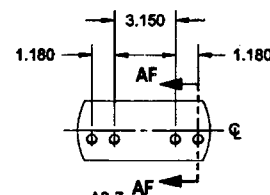
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TWIST ON FWD BEND
(VIEWED LOOKING FWD)



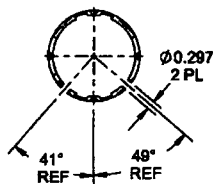
DETAIL AA
SCALE 2X



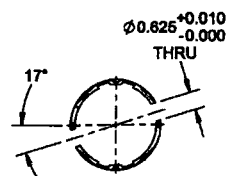
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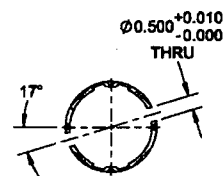
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



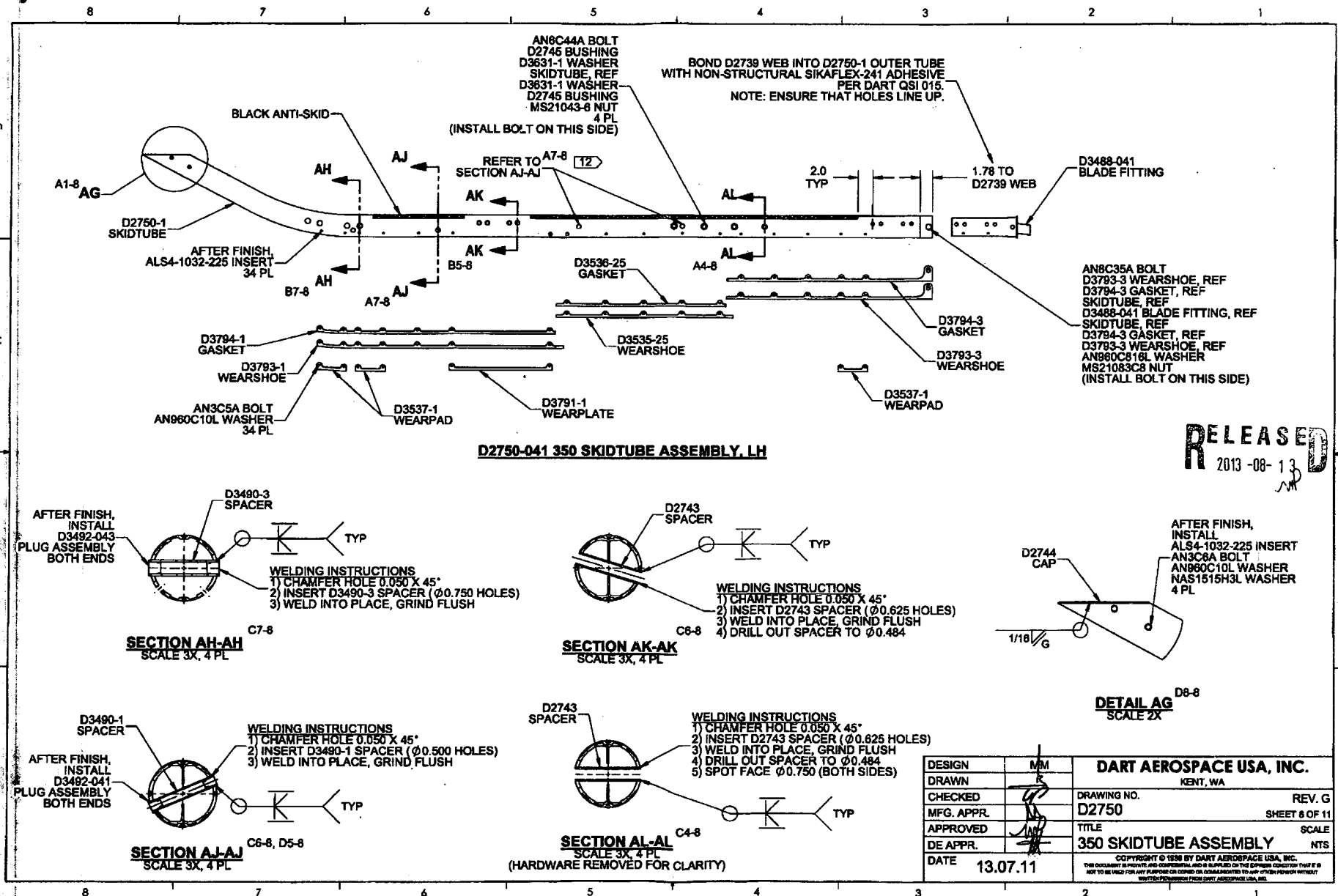
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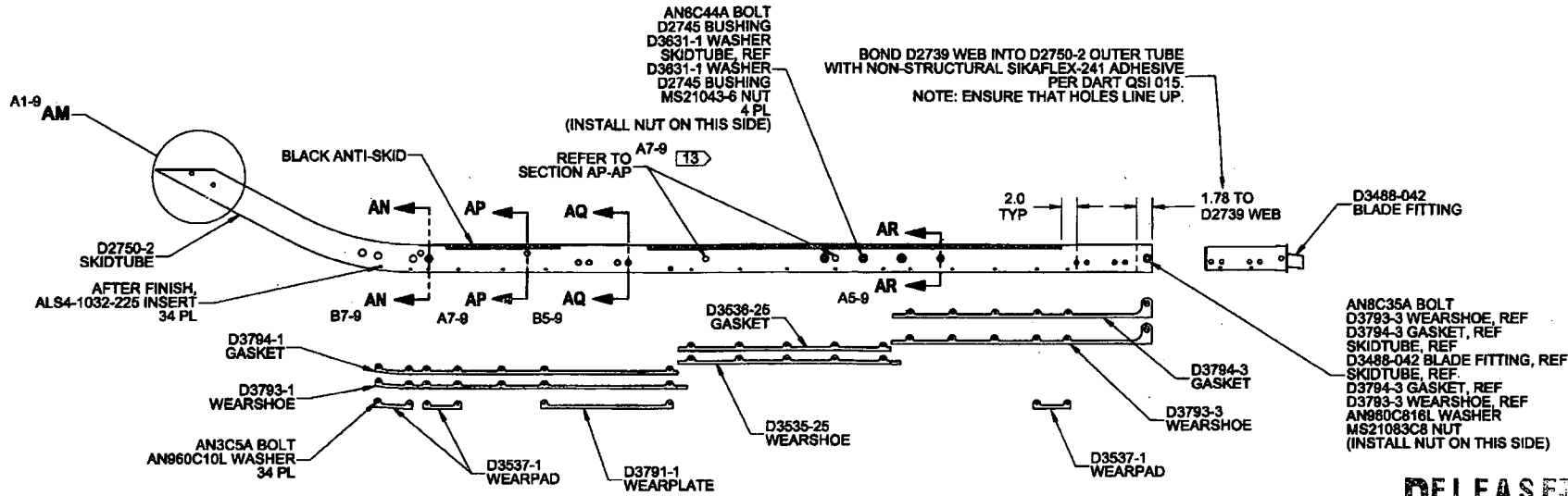
SECTION AF-AF
SCALE 3X, 4 PL

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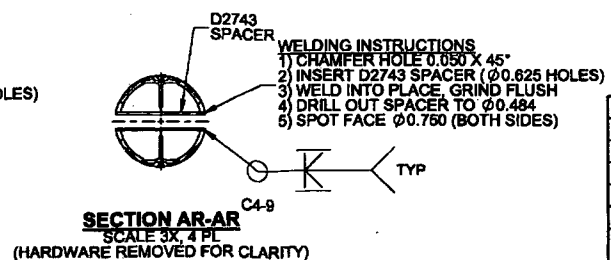
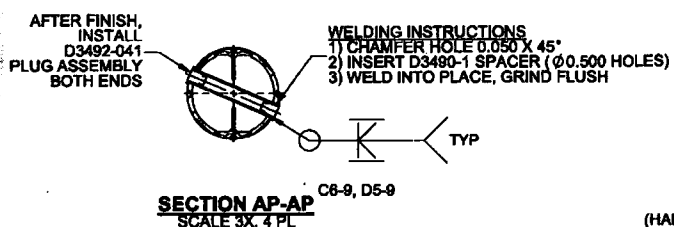
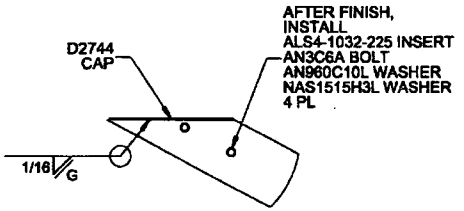
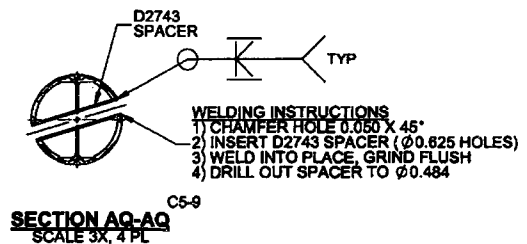
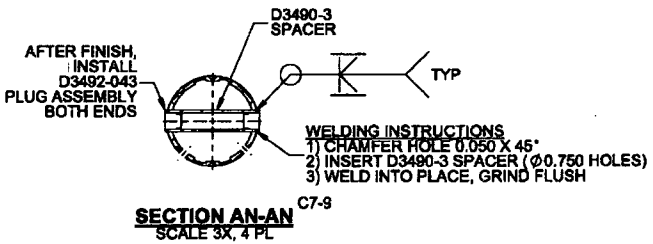


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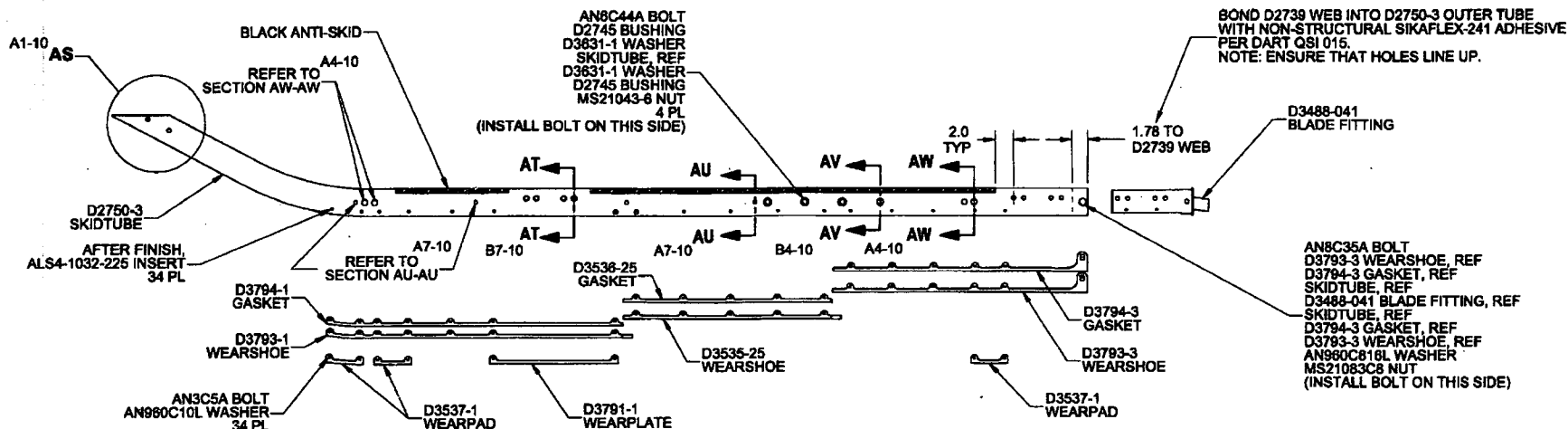
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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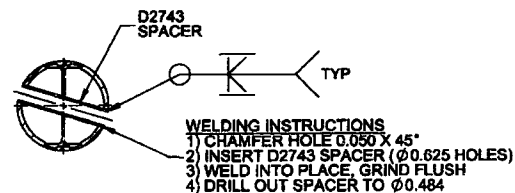
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8 7 6 5 4 3 2 1

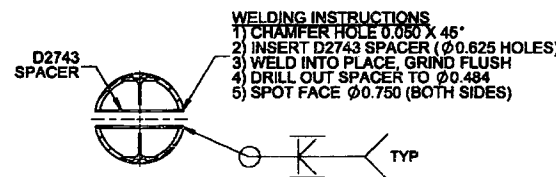


D2750-043 350 SKIDTUBE ASSEMBLY, LH

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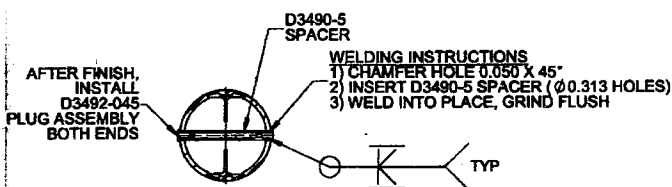


SECTION AT-AT SCALE 3X, 4 PL

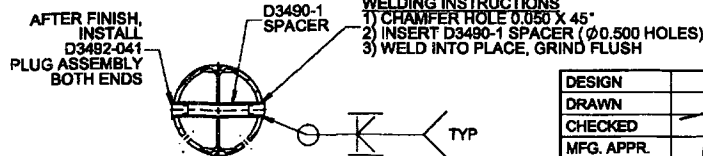


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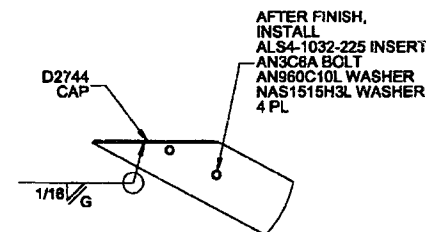
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU SCALE 3X, 4 PL



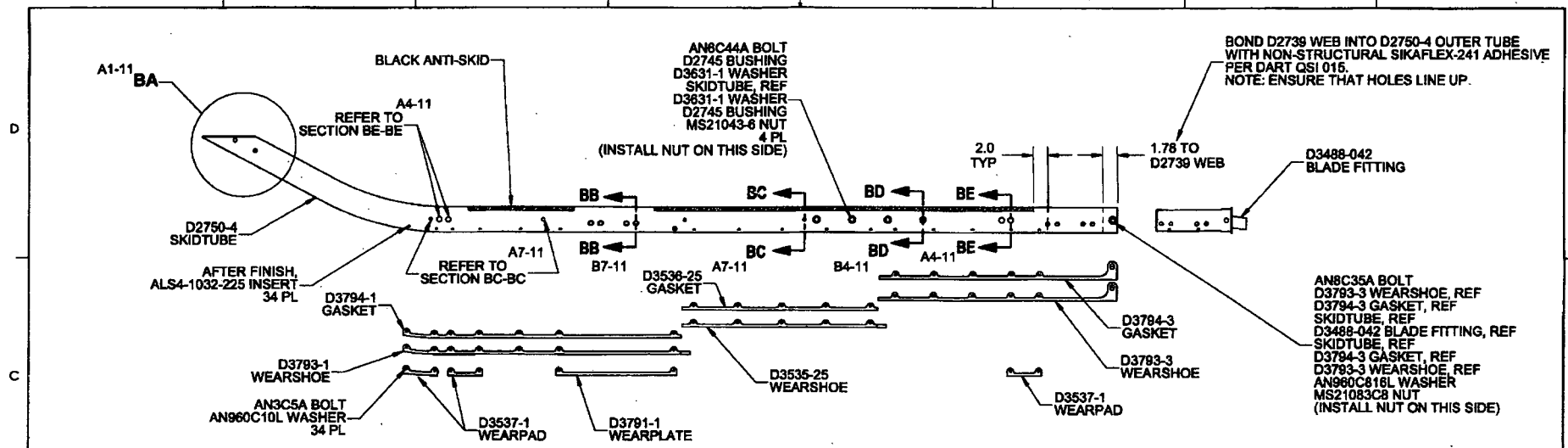
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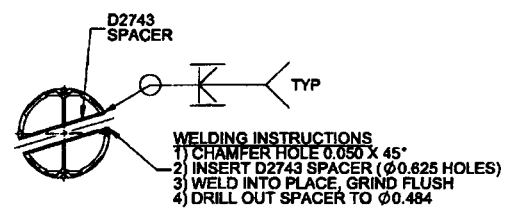
DETAIL AS SCALE 2X

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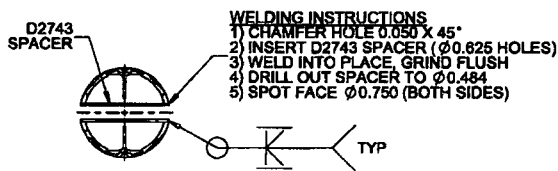
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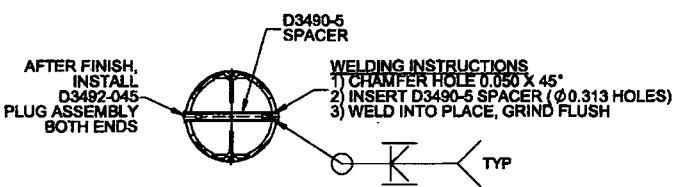
D2750-044 350 SKIDTUBE ASSEMBLY, RH



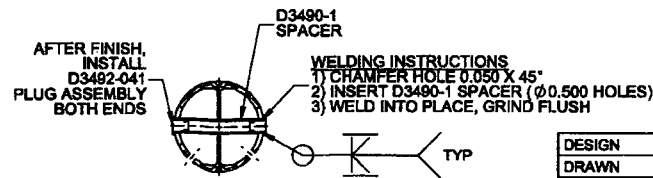
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SCALE 3X, 4 PL



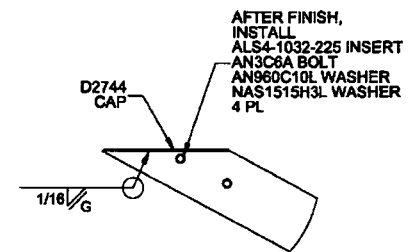
SECTION BD-BD
D4-11
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
D5-11, C8-11
SCALE 3X, 4 PL



SECTION BE-BE
D4-11, D7-11
SCALE 3X, 4 PL



DETAIL BA
D8-11
SCALE 2X

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No. 337

AWS D17.1/D17.1M:2010 SKIDTUBE WELDING TEST RECORD

Name: Barclay Elliott
Job #: B109371
Part #: D350-636-012
Description: 350 skid tube
Welding Process: TIG [☒] MIG [☐]
Base Material: Aluminum
Current: AC [☒] DC [☐]

TEST REQUIREMENTS AND RESULTS

Visual:	pass [✓] fail []
Penetration:	pass [✓] fail []
Fusion:	pass [✓] fail []
Cracks:	pass [✓] fail []
Overlap (cold lap)	pass [✓] fail []
Undercut:	pass [✓] fail []
Pin holes:	pass [✓] fail []
Porosity (surface):	pass [✓] fail []
Coloration:	pass [✓] fail []
Burn through:	pass [✓] fail []

Qualifier: DAS
9
9-89

Date of Test Coupon: 13-12-03

Welder: Bryan Elliott

Date of Test Coupon: 13-12-03

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.